

Date: Friday, 10/13/2006 9:27:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 28963	
Estimate Number : 12428	
P.O. Number : N/A	Part Number : D35061
This Issue : 10/13/2006 S.O. No. : N/A	Drawing Number : D3506 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27714	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 10/30/2006 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u> 061013	
Comment : Est Rev: A New Issue 06-05-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S100	6061-T6 .100 Sheet
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Comment: Qty.: 0.0082 sf(s)/Unit Total: 0.1638 sf(s)

6061-T6 .100 Sheet

(M6061T6S0100)

Batch: M102201ml 061109

(20)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3506

Dwg Rev: AProg Rev: Aml 061109

(20)

2-Deburr if necessary

S40 06:10:14

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINES40 06:10:14

20

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA640 and Dwg D3506

J.F. 07/03/01

(20)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEJ.F. 07/03/01

(20)

→ 3.1 | QC 8
 Second check

1/12/06/11/10

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3506-1 PAR #: _____ Fault Category: Prod/Engineering NCR: (Yes) No DQA: (S) Date: 07/03/06
 could not QA: N/C Closed: (S) Date: 07.03.09

NCR: <u>28963</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/02	2.0 3.0	Parts do not have 45° chamfer was not in the Dxf when the parts were cut on the water jet, and the chamfer wasn't picked up on the F.A.I.	<u>(Signature)</u>	Qty 20 ScrAP. 3 Replace	<u>(Signature)</u> 06/11/09	<u>(Signature)</u>	<u>(Signature)</u>	<u>(Signature)</u>

NOTE: Date & initial all entries

Date: Friday, 10/13/2006 9:27:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 28963

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Ep 07/03/05

(PTU)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
C'sink as per Dwg D3506(On Flat side)

SAO 07/03/05 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/05 (20)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M-H

07/03/05

(20x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/05 (20x) / U

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/03/05 (20x)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/06

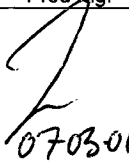
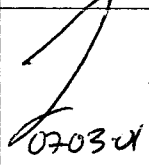
(20)

Job Completion



11 07-03-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
070301	5.0	Add A thickness to dimension to the drawing for how thick the material has to be machined down to in the middle of the Radius. = 060" thick at the center.				 070301	 070301	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

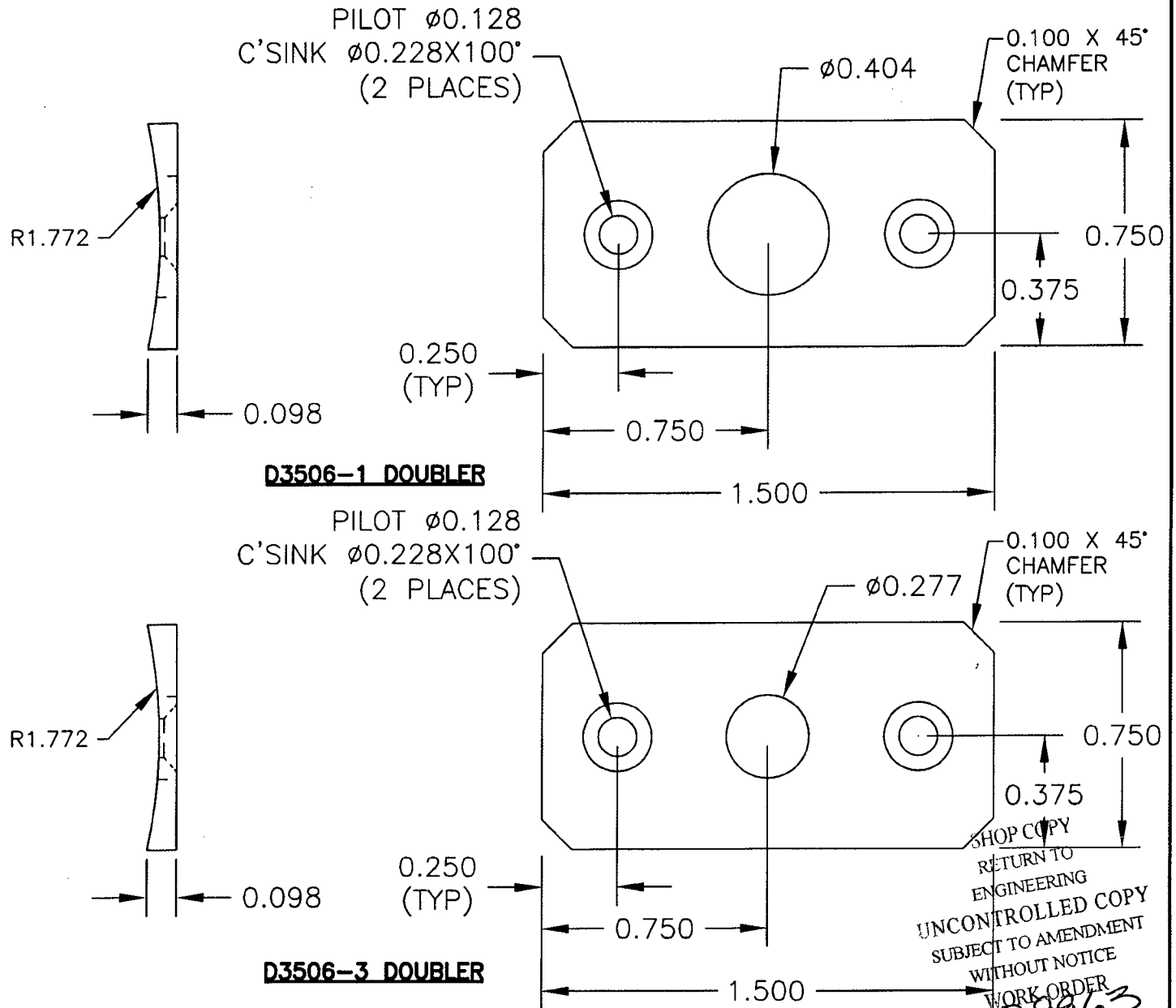
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK)
(REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28963
RELEASED
06.10.03 PH
PER ECN #861

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DART AEROSPACE LTD	Work Order: Q8963
Description: Doubler	Part Number: D3506-1
Inspection Dwg: D3506 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	<i>MM. MM</i>
Date:	<i>03 11 09</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	